

Del 150

## Work Order ID 69895

Tuesday, May 24, 2011 10:07:54 AM



Page 1

Item ID: D3532-1

Accept



Setup Start



Revision ID:

Item Name: Spacer

Stop



Start Date: 5/24/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:



Date: 11-05-24 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

| Draw Nbr        | Revision Nbr | Memo                                    | 0.00   | 40 | 40 |
|-----------------|--------------|---|--|----|----|
| D3532           | Rev A        | Hardinge CNC LATHE SMALL                | 0.00   |    |    |
| 100             |              | Hardinge                                | 0.00   |    |    |
|                 |              | Hardinge CNC Lathe Small                | 1-TURN AS PER FOLIO FA641 & DWG D3532 , <input type="checkbox"/> FOLIO<br>REV: <input checked="" type="checkbox"/> DWG REV: <input checked="" type="checkbox"/> Q2-DEBURR AS REQUIRED. |    |    |
| 110             |              | QC2- Inspect parts off machine FAI/FAIB | 0.00   | 40 | 40 |
|                 |              | Memo                                    | 0.00   |    |    |
| QC              |              |   |  |    |    |
| Quality Control |              |   |  |    |    |
| 120             |              | QC8- Inspect parts - second check       | 0.00   | 40 | 40 |
|                 |              | Memo                                    | 0.00   |    |    |
| QC              |              |   |  |    |    |
| Quality Control |              |   |  |    |    |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 69895**

Page 2

Tuesday, May 24, 2011 10:07:54 AM

Item ID: D3532-1

Accept



Setup Start



Revision ID:

Item Name: Spacer

Stop



Start Date: 5/24/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

130



Packaging

Packaging

Operation  
DescriptionIdentify as per dwg & Stock Location: 65Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

11/15/31

SF

(40)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/15/31 JJ

MF

11-05-31

Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |  |  |    |      |     |                                     |                          |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |  |    |      |     |                                     |                          |
|      |      |                    |  |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

Page 1

Tuesday, May 24, 2011 10:08:02 AM

Work Order ID: 69895



Parent Item: D3532-1



Parent Item Name: Spacer.

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 06-07-12 EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MDELRINR0.750                   |                        | Purchased     | No          |                     |                  | f               |                    | 73.2000        |             | 1.2          |               | 5/31           |        |

Delrin Round Bar 0.75"



| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT055          | 73.2           |                 |
| 115472          | 7.5            |                 |
| 116183          | 3.6            |                 |
| 117273          | 56             |                 |
| 117322          | 6.1            |                 |

1.2 ft

Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |  |  |    |      |     |                                     |                          |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |  |    |      |     |                                     |                          |
|      |      |                    |  |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |  |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|--|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                |  | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |  |                           |                       |                          |
|      |      |                                  |                             |                                 |                |  |                           |                       |                          |
|      |      |                                  |                             |                                 |                |  |                           |                       |                          |
|      |      |                                  |                             |                                 |                |  |                           |                       |                          |

NOTE: Date & initial all entries

|                              |              |             |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD           | Work Order:  | C9895       |
| Description: Spacer          | Part Number: | D3532-1     |
| Inspection Dwg: D3532 Rev: A |              | Page 1 of 1 |

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

|              |           |             |           |                     |     |
|--------------|-----------|-------------|-----------|---------------------|-----|
| Measured by: | <u>SJ</u> | Audited by: | <u>RS</u> | Prototype Approval: | N/A |
| Date:        | 11/5/31   | Date:       | 11-5-31   | Date:               | N/A |

| <b>Rev</b> | <b>Date</b> | <b>Change</b> | <b>Revised by</b> | <b>Approved</b> |
|------------|-------------|---------------|-------------------|-----------------|
| A          | 07.10.09    | New Issue     | KJ/EC/DD          | 2/2             |

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

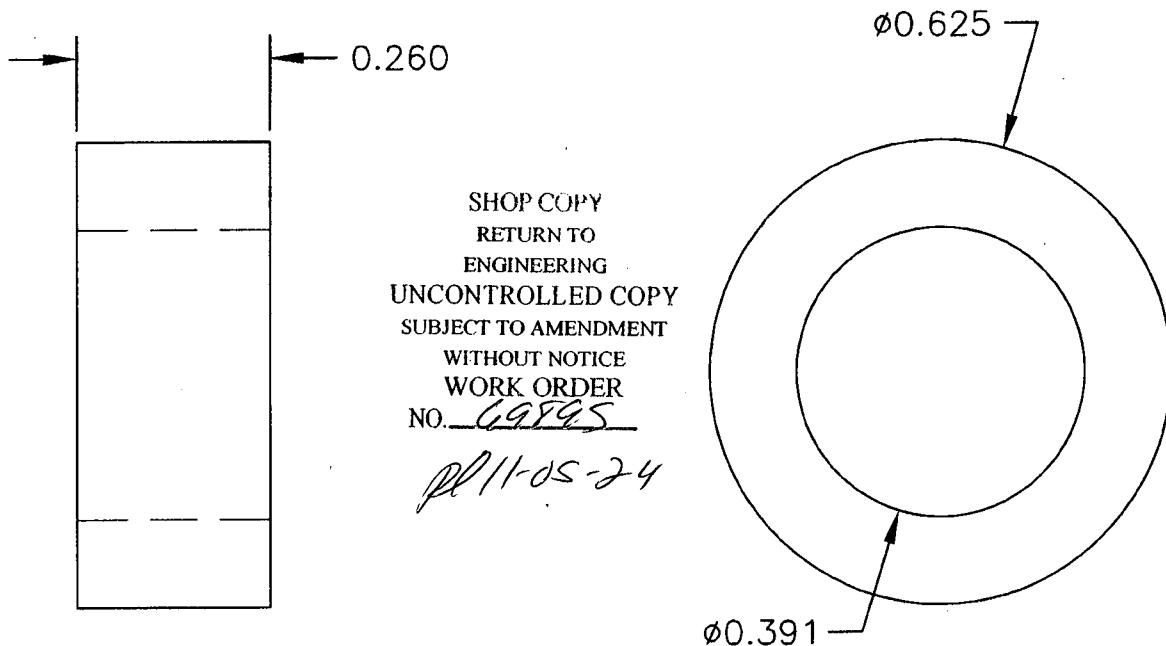
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                      |                                 |           |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action    |                                 | Section B |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng |           | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |
|      |      |                                  |                      |                                 |           |                |                           |                       |                          |

NOTE: Date &amp; initial all entries

**DART**

|                              |                               |  |                        |
|------------------------------|-------------------------------|--|------------------------|
| DESIGN<br><i>PH</i>          | DRAWN BY<br><i>PH</i>         | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA |                        |
| CHECKED<br><i>[initials]</i> | APPROVED<br><i>[initials]</i> | DRAWING NO.<br>D3532                         | REV. A<br>SHEET 1 OF 1 |
| DATE<br>06.06.26             |                               | TITLE<br>SPACER                              | SCALE<br>4:1           |
| A                            | 06.06.26                      | NEW ISSUE                                    |                        |

**D3532-1 SPACER****D3532-1 SPACER**

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-RD.DDD)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
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| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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|      |      |                                  | Initial<br>Chief Eng | Action Description<br>Chief Eng | Sign &<br>Date |  |                           |                       |                          |
|      |      |                                  |                      |                                 |                |  |                           |                       |                          |
|      |      |                                  |                      |                                 |                |  |                           |                       |                          |
|      |      |                                  |                      |                                 |                |  |                           |                       |                          |

NOTE: Date & initial all entries